

Thursday, 12/13/2007 2:39:06 PM
Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG ASSEMBLY
Job Number : 36330	
Estimate Number : 10011	
P.O. Number : N/A	Part Number : D27361
This Issue : 12/13/2007 S.O. No. : N/A	Drawing Number : D2736 REVA
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : A
Previous Run : 34816	Material : N/A
	Due Date : 1/10/2008
Written By : <u>AJ02.12.13</u>	Qty <u>45</u> Um: Each
Checked & Approved By : <u>AJ02.12.13</u>	
Comment : Est Rev:D Removed from 9 digit 05-10-25 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2591	Lug
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

Qty	Part Number	Description
1	D2591	Lug

Batch
B3S659

FC 08 01 09 (15)

2.0	D27351	Lug Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

Qty	Part Number	Description
1	D2735-1	Lug Bracket

Batch
B34830

FC 08 01 09 (15)

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Weld D2591 & D2735-1 as per OSI 004 and Dwg D2736 using locating Jig DT8484

Steel Rod Batch: m100572

FC 08 01 09 (15)

4.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

FC 08-01-10

5.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

FC 08/01/10 (45)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: 12 Date: 28/01/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 36330

Part Number: D27361

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



M106379



(45X)

Comment: HAND FINISHING RESOURCE #1

Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3

M-1

08/01/12

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(45)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Bk

08-01-12

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

471A

8/1/14

50

(45X)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



45

Comment: FINAL INSPECTION/W/O RELEASE

08/01/15

Job Completion



K 08-01-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

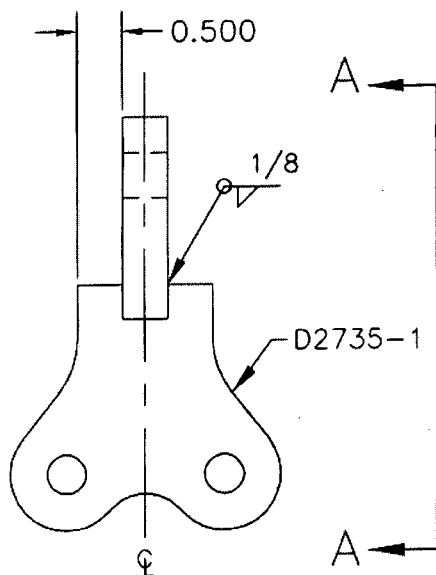
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

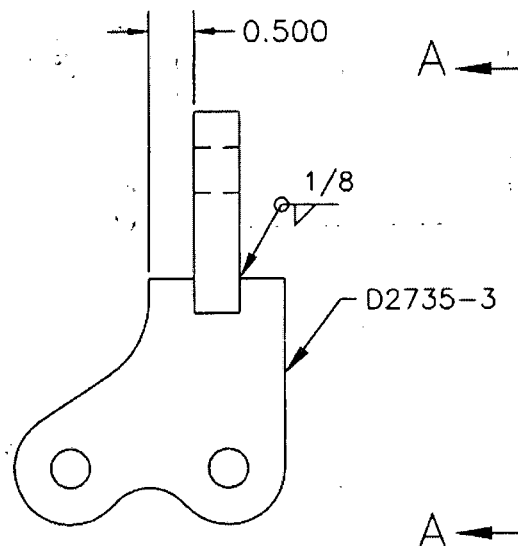
NOTE: Date & initial all entries



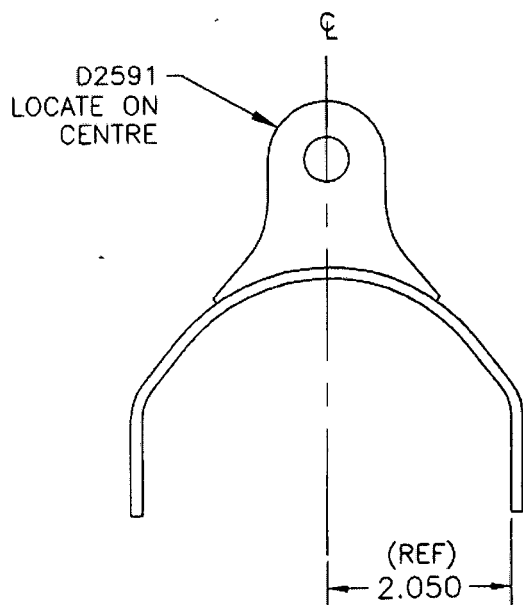
DESIGN <i>MM</i>	DRAWN BY <i>MM</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>MM</i>	DRAWING NO. D2736	REV. A SHEET 1 OF 1
DATE 97.12.18		TITLE LUG ASSEMBLY	SCALE NTS
A	97.12.18	NEW ISSUE	



D2736-1 LUG ASSEMBLY



D2736-3 LUG ASSEMBLY



VIEW A-A

NOTES:

WELD PER DART QSI 004

FINISH: POWDER COAT WHITE PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

PART IS SYMMETRIC ABOUT CENTRE-LINES (⊙)

RELEASED

ECN 057

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **36330**